

Date: Wednesday, 6/20/2007 11:21:32 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD X-TUBE
Job Number	: 33025		
Estimate Number	: 10006		
P.O. Number	: N/A	Part Number	: D2889
This Issue	: 6/20/2007 S.O. No. : N/A	Drawing Number	: D2889 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: B
Previous Run	: 33024	Material	: N/A
Written By	:	Due Date	: 6/27/2007
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: Est Revis New Issue 05-10-25 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6005180	Crosstube material
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Crosstube material

Pick:

Qty	Part number	Description	Batch
1	D2889	Fwd Crosstube	25673

EL 7-6-26

2.0	BENDING	BENDING MACHINE
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Comment: LANDING GEAR RESOURCE 1

1-Bend D2889 as per Dwg D2889 and Folio FT001

EL 7-6-26

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Deburr and Polish

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and alodine as per QSI 005 4.1  
 Inside and outside of tube

N/A

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: R1 Date: 07/01/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 6/20/2007 11:21:32 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE

Job Number: 33025

Part Number: D2889

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*UAF*

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *W10 32939*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



*(1)*

Comment: FINAL INSPECTION/W/O RELEASE

*9/27/04*

Job Completion



*U 9/27/04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

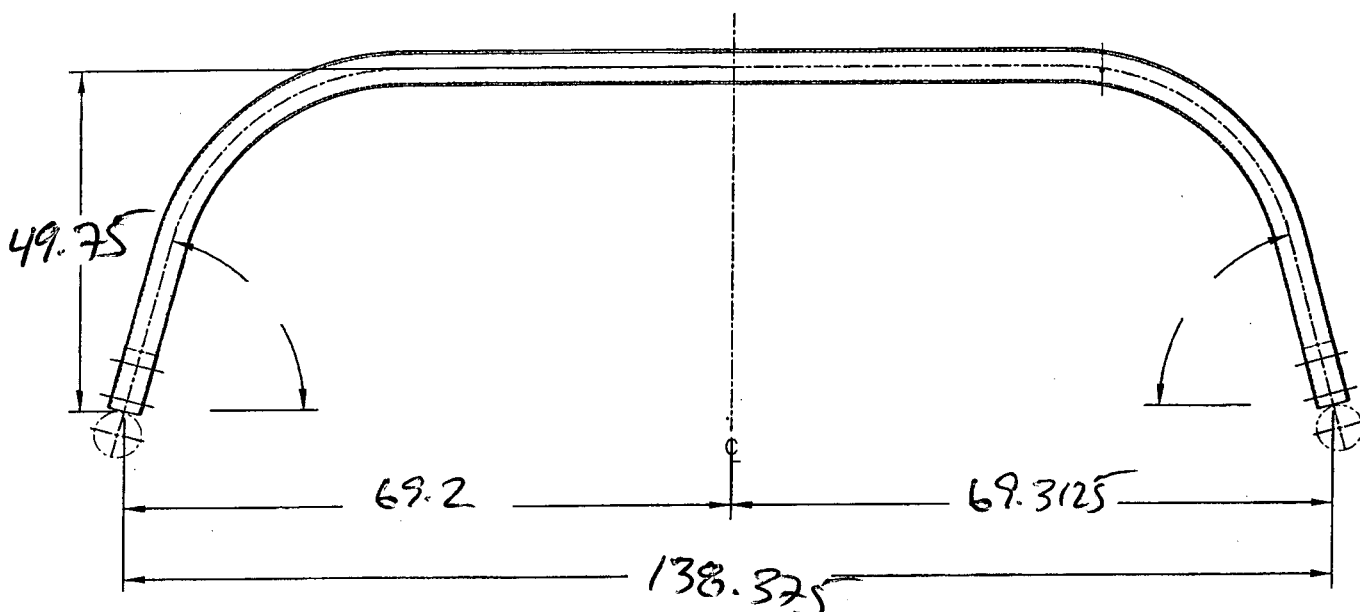
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	33025
Description: Crosstube Fwd		Part Number:	D2889
Inspection Dwg: D2889		Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



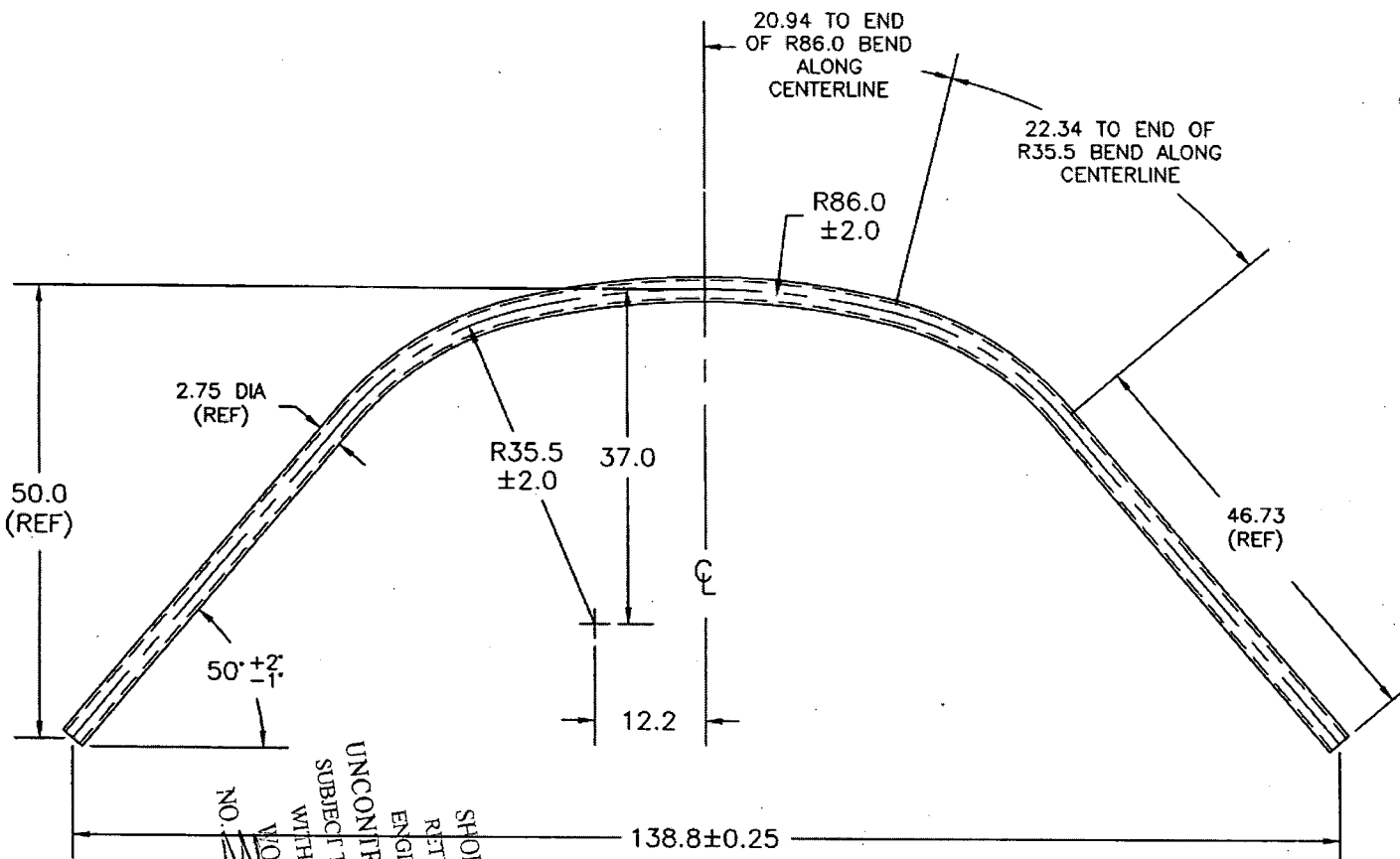
Comments
Tube is to be cut per - 101 B32939

QC15 Inspection	<i>[Signature]</i> 070704
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

**DART****RELEASED**  
02.10.28

DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED		APPROVED		DRAWING NO.	
#		#		D2889	
DATE		TITLE		REV. B	
02.10.18		FWD CROSSTUBE		SHEET 1 OF 1	
A		99.05.21		SCALE	
B		02.10.18		1:20	
		NEW ISSUE		ADD TANGENT LENGTHS; CHANGE NOTES	

**NOTES**

- 1) MATERIAL: MANUFACTURE FROM D6005-180 (Ø2.75 OD x 0.375 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.